



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200

D4776-5
Job Sheet 180913



Part No: D4776-5

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS
PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		7/31/18	0.00	0.00	Start Up Machining-3		
100	Doosan	60 pcs		7/31/18	0.05	3.35	Doosan		
120	QC	60 pcs		7/31/18	0.00	0.00	QC8		
130	HandFinish	60 pcs		7/31/18	0.00	0.29	HandFinish1		
140	QC	60 pcs		7/31/18	0.00	0.00	QC7-4		
150	Packaging	60 pcs		7/31/18	0.00	0.00	Packaging3-2		
160	QC21-SA	60 Ea		7/31/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - 1-Turn as per Folio and Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	1.2000 ft (.02 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	1	36	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches ± 0.030	0.160 0.100		
2	Spacer	0.250Inches ± 0.030	0.280 0.220		
3	Spacer	0.625Inches ± 0.010	0.635 0.615	Diameter	
4	Spacer	0.438Inches ± 0.010	0.448 0.428	Diameter	
5	Spacer	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																															
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Descr: _____ Container No: S102271 Part: D4776-5 Job No: 180913 Serial No/Batch: S102271 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's		Disposition 		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																															
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